

Work Order ID 53519

November 9, 2009 7:21:39 AM



Page 1

Item ID: D6102-010

Accept



Setup Start



Revision ID: D

Stop



Item Name: Saddle Billet

Start Date: 11/09/09 Start Qty: 40.00



Cust Item ID:

Required Date: 11/16/09 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: CL

Date: 09/11/09 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D6102 | Rev D | | | | | | | | |

100

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 10723 (a) Description: Aluminum Billet (b) 7.950" x 8.250" x 2.500" thick (c) Tolerance on all dimensions is +0.06/0.00 (d) Grain direction along 7.950" length (e) Material: 6061-T6/T6511 (QQ-A-250/11 or QQ-A-200/8) (f) Material release certifi

CL 09/11/09 (40)

110

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

Ensure material certification is attached

CL 9/14/12 (40)

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

Check certification to Dwg D6102 for compliance

CL 09/11/12

40

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 53519

November 9, 2009 7:21:39 AM



Page 2

Item ID: D6102-010

Accept



Setup Start



Revision ID: D

Stop



Item Name: Saddle Billet

Start Date: 11/09/09 Start Qty: 40.00



Cust Item ID:

Required Date: 11/16/09 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|-----------------------------------|--|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
| 130 Packaging Packaging | Identify as per dwg & Stock Location: <u>MAT</u> Memo | 0.00 0.00 | | | | | | | |
| 140 QC Quality Control | QC21 - Final Inspection - Work Order Release Memo | 0.00 0.00 | | | | | | | |

MF 09-11-12

09/11/13

MF

09-11-12

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

November 9, 2009 7:21:39 AM

Page 1

Work Order ID: 53519



Parent Item: D6102-010RevD



Parent Item Name: Saddle Billet

Start Date: 11/09/09

Required Date: 11/16/09

Comments:

Start Qty: 40.00

Required Qty: 40.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|

D6102-010PRevD

Purchased

No

110

Each

0.0000

40.0000



6061-T6 8.25x7.95x2.5



PC 9/4/12 (40)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

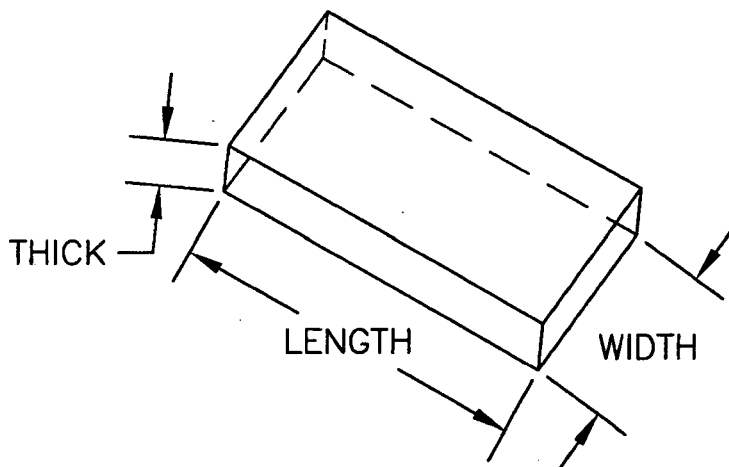
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



| | | | |
|------------------|----------------|--|------------------------|
| DESIGN # | DRAWN BY PH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED CP | APPROVED # | DRAWING NO. D6102 | Rev. D SHEET 1 OF 1 |
| DATE 06.06.30 | | TITLE SADDLE BILLET, 6061 | SCALE NTS |
| A | 01.03.30 | NEW ISSUE | |
| B | 03.10.20 | ADD D6102-005/-007/-009 | |
| C | 04.08.25 | ADD D6102-010/-011 | |
| D | 06.06.30 | ADD D6102-013 | |

SPECIFICATION CONTROL DRAWING



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 53519
C209111109

RELEASED

06.08.15 #

PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.06/-0.00), AND GRAIN DIRECTION AS SHOWN.

TOLERANCE ON ALL DIMENSIONS IS +0.06/-0.00.

ALL DIMENSIONS ARE IN INCHES.

| Part No. | Alloy | Length | Width | Thick | Grain Direction |
|-----------|--|--------|--------|-------|---------------------|
| D6102-001 | 6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8) | 7.880 | 6.250 | 2.000 | Along 7.880 Length |
| D6102-003 | 6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8) | 6.000 | 6.250 | 2.000 | Along 6.000 Length |
| D6102-005 | 6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8) | 47.85 | 15.250 | 1.000 | Along 47.85 Length |
| D6102-007 | 6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8) | 7.500 | 7.000 | 2.500 | Along 7.500 Length |
| D6102-009 | 6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8) | 11.000 | 6.000 | 5.000 | Along 11.000 Length |
| D6102-010 | 6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8) | 7.950 | 8.250 | 2.500 | Along 7.950 Length |
| D6102-011 | 6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8) | 6.500 | 8.250 | 2.500 | Along 6.500 Length |
| D6102-013 | 6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8) | 6.500 | 7.000 | 2.000 | Along 6.500 Length |

09/11/12

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO10723

Purchase Order Date 11/09/09

PO Print Date 11/09/09

Page Number 1 of 2

Order From :

VC-MAG002

MAGNA STAINLESS
5775 RUE KIERAN
ST LAURENT, QC H4S 0A3
CA

FAXED

Contact Name
Vendor Phone 800 363 6646
Vendor Fax 514 339 1105
Vendor Account Nbr

Buyer Chantal Lavoie
Requisition Nbr
Tax Resale Nbr 10127-2607
Terms Net 30
Currency CAD
FOB

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

| Line Nbr | Reference Revision ID Vendor Part Number | Description/ Mfg ID | Req Date/ Taxable | Req Qty/ Unit of Measure | Ship Method | Unit Price | Extended Price |
|----------|--|------------------------|---|-----------------------------|-------------|------------|-------------------|
| 1 | D6102-010P D | 6061-T6 8.25x7.95x2.5 | 11/16/09 Yes | ✓ 40.00 Each | Yours ppd | \$62.0000 | \$2,480.0 |
| | | Special Inst: | MATERIAL: 6061-T6/T6511 (QQ-A-250/11 OR QQ-A-200/8 OR AS PER AMS 4025/AMS 4027 OR ASTM B209 BILLET SIZE: 7.950" X 8.250" X 2.500" THICK GRAINN DIRECTION ALONG 7.950" LENGTH TOLERANCE ON ALL DIMENSION IS +0.06/0.00 B53519 | | | | |
| 2 | D6102-011P D | 6061-T6 8.25x6.5x2.5 | 11/16/09 Yes | ✓ 40.00 Each | Yours ppd | \$50.0000 | \$2,000.0 |
| | | Special Inst: | MATERIAL AS ABOVE BILLET SIZE: 6.500" X 8.250" X 2.50" THICK GRAIN DIRECTION ALONG 6.500" LENGTH TOLERANCE ON ALL DIMENSIONS IS +0.60/0.00 B53520 | | | | |

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 1

Change Date: 11/09/09



Magna Stainless

5775 Kieran St, Saint-Laurent, Quebec H4S 0A3
Phone: (514) 339-1211 Watts: 1-800-363-6646 Fax: (514) 339-1105



PACKING LIST

Page 1 of 1

I019360

SOLD TO:
DART AEROSPACE LTD
1270 ABERDEEN STREET

SHIP TO:
DART AEROSPACE LTD
1270 ABERDEEN STREET

HAWKESBURY, ON
K6A 1K7
Contact:

HAWKESBURY, ON
K6A 1K7
Ship Terms: PREPAID

MTR:Y

SPECIAL INSTRUCTIONS

| Currency | | Sales Person | Customer Phone | Customer Fax | Customer PO | |
|------------------|-------------|--------------|----------------|----------------|---------------|--------------|
| CANADIAN DOLLARS | | ERYCK BLAIS | (613) 632-5200 | (613) 632-1053 | LINDA | 10723 |
| Sales Order | Terms | | Ship Via | Date Ordered | Date Required | Date Shipped |
| W021078 | NET 30 DAYS | | NIR:R-557065-1 | 11/09/09 | 11/16/09 | 11/12/09 |

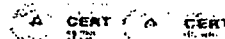
| Ordered | Back Ordered | Unit | Description | Bundle # | Heat # | Shipped |
|----------|--------------|------|---|----------|---------|----------|
| 40 | | PC | ALUMINUM - LB 6061-T6 2 1/2" X 8.250" X 7.95" GR | | | 40 |
| | | | 656 LB / 40 PC | L033106 | 628628 | 40 |
| 40 | | PC | 6061-T6 2 1/2" X 8.250" X 6.50" GR | | | 40 |
| | | | 537 LB / 40 PC | L033107 | 625696 | 40 |
| Skids: 2 | | | | Approx | Weight: | 1,193 LB |

Received by: _____ Date: _____ Signature: _____



INSPECTION CERTIFICATE № 09.19375

EN 10204 - 3.1



Consignor: KAMENSK URALSKY METALLURGICAL WORKS JOINT STOCK COMPANY
5, Zavodskaya Str., Kamenisk Uralsky, Sverdlovsk Region, 623406 Russia Tel: (3439) 39 52 22 Fax: (3439) 39 50 58

Consignee: Quantity: 1

Contract number: N11387-S Net Weight, kg: 980
P60727DK010 Specification №: N11387
Article number: Lot №: 1
Package №: 608063

Description of Goods: Plates Requirements on the Product:
Grade of Product: Dimensions, inch/mm: Metals conforms to quality of alloy: 6081 T851
2.5"X60.5"X144.5"
63.500X1535.7X3670.3 Product conforms to all requirements of
ASTM-B209-07, AMS-QQ-A250/11AMS4027N. This
product conforms to European Union RoHS Directive
2002/95/EC

Mechanical Properties

| The Condition of Tested Standards | Lot Number | Cert Number | Number of Tests | Tensile Strength | | Yield Strength (0.2% offset) | | Elongation, % | | Hardness HB |
|-----------------------------------|------------|-------------|-----------------|------------------|------|------------------------------|------|---------------|------|-------------|
| | | | | ksi | ksi | ksi | ksi | min | max | |
| Required | | | | 42.0 | - | 35.0 | - | 6.0 | - | - |
| | 628628 | 13-5016 | 1 | 48.1 | 48.1 | 44.8 | 44.8 | 12.0 | 12.0 | - |

Chemical Composition, %

| Element | Silicon Si | Iron Fe | Copper Cu | Manganese Mn | Magnesium Mg | Chromium Cr | Nickel Ni | Zinc Zn | Titanium Ti | Zirconium Zr |
|----------|------------|---------|-----------|--------------|--------------|-------------|-----------|---------|-------------|--------------|
| Required | 0.4-0.8 | 0.7 | 0.15-0.40 | 0.15 | 0.8-1.2 | 0.04-0.35 | - | 0.25 | 0.15 | - |
| Contents | 0.63 | 0.2 | 0.22 | 0.03 | 1.0 | 0.05 | - | 0.03 | 0.09 | - |

| Element | Ti+Zr | Al |
|----------|-------|----|
| Required | - | - |
| Contents | - | - |

Other Tests

| Method | Macro-structure | Micro-structure | USI | Electro-conductivity | Contents H2 of metals cm3/100g | Marking - Free |
|--------|-----------------|-----------------|-----|----------------------|--------------------------------|---|
| Result | - | - | - | - | 0.23 | "Russia is country of melt and manufacture" |

On behalf:

KUMW, JSC.

Date:

24.08.09

Inspector:

K.V. Ziryayeva

Inspection Department engineer

N.V. Alekhina



Inc 11-11-09

S91106DG012-1 MAGNA STAINLESS PO: P007673 Part #: 40.00PC

P007673



INSPECTION CERTIFICATE № 09.15153

EN 10204 - 3.1

| | | | | | | | | | | | | | | | | | | | |
|---|---------------------|---------------------|--------------------|--------------------------|-----------------------------------|---------------------------------|---|----------------|----------------|--|--|--|--|--|--|--|--|--|--|
| Consigner: KAMENSK URALSKY METALLURGICAL WORKS 5, Zavodskaya Str., Kamensk Ural'sky, Sverdlovsk Region, 623405, Russia Tel: (3439) 39 52 22 Fax: (3439) 39 50 55 | | | | | | | | | | JOINT STOCK COMPANY | | | | | | | | | |
| Consignee: | | | | | | | | | | Quantity: 2 | | | | | | | | | |
| Contract Number: N11298-S P90818DK006 | | | | | | | | | | Net Weight, kg.: 2520 | | | | | | | | | |
| Article number: | | | | | | | | | | Specification Nr.: N11298 Lot No.: 1 Package Nr.: 606508, 606509 | | | | | | | | | |
| Description of Goods: Plates | | | | | | | | | | Requirements on the Products: | | | | | | | | | |
| Grade of Product: | | | | | Dimensions, inch/mm: | | | | | Material conforms to quality of alloy: 6061 T851 | | | | | | | | | |
| 2.5"X78.5"X145" | | | | | 63.500X1983.8X3683.0 | | | | | Product conforms to all requirements of ASTM-B209-07, AMS-QQ-A250/11AMS4027N, This product conforms to European Union RoHS Directive 2002/95/EC | | | | | | | | | |
| Mechanical Properties | | | | | | | | | | | | | | | | | | | |
| The Condition of Tested Standards | Lot Number | Cast Number | Number of Tests | Tensile Strength | | Yield Strength (0.2% offset) | | Elongation, % | | Hardness, HB | | | | | | | | | |
| | | | | ksi | ksi | ksi | ksi | ksi | ksi | | | | | | | | | | |
| Required | | | | min | max | min | max | min | max | | | | | | | | | | |
| | 625608 | 20-2882 | 2 | 42.0 | - | 35.0 | - | 6.0 | - | - | | | | | | | | | |
| | | | | 48.1 | 48.1 | 43.2 | 43.2 | 10.0 | 12.0 | - | | | | | | | | | |
| Chemical Composition, % | | | | | | | | | | | | | | | | | | | |
| Element | Silicon Si | Iron Fe | Copper Cu | Manganese Mn | Magnesium Mg | Chromium Cr | Nickel Ni | Zinc Zn | Titanium Ti | Zirconium Zr | | | | | | | | | |
| Required | 0.4-0.8 | 0.7 | 0.15-0.40 | 0.15 | 0.8-1.2 | 0.04-0.35 | - | 0.25 | 0.15 | - | | | | | | | | | |
| Contents | 0.87 | 0.2 | 0.20 | 0.15 | 1.0 | 0.05 | - | 0.11 | 0.08 | - | | | | | | | | | |
| Element | Ti+Zr | Nb | Ta | Aluminum Al | Platinum Pt | Vanadium V | Ca | Other Elements | | Al | | | | | | | | | |
| | | | | | | | | Each | Total | | | | | | | | | | |
| Required | - | - | - | - | - | - | - | 0.05 | 0.15 | remainder | | | | | | | | | |
| Contents | - | - | - | - | - | - | - | 0.05 | 0.15 | remainder | | | | | | | | | |
| Other Tests | | | | | | | | | | | | | | | | | | | |
| Method | Macro- structure | Micro- structure | UT | Electro- conductivity | Contents H2 of metals end/100g | | Mercury - Free "Russia is country of melt and manufacture" | | | | | | | | | | | | |
| Result | - | - | - | - | 0.20 | | | | | | | | | | | | | | |

On behalf:

KUMW, JSC.

Date:

08.07.09

Inspector:

G.A. Ostarina

Inspection Department Engineer

N.V. Alekhina

Inc 11-11-09